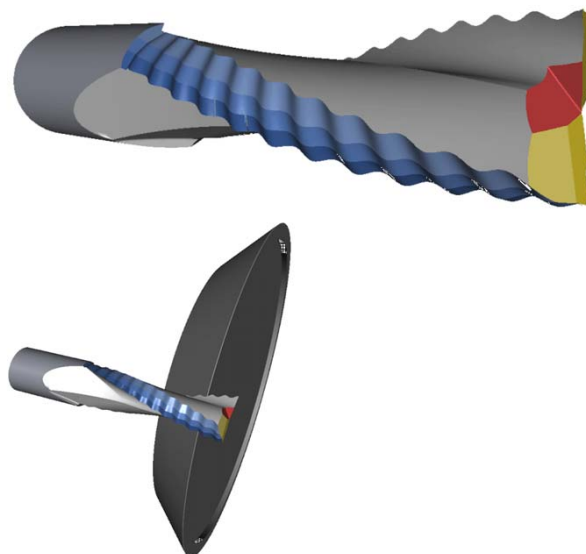



















Roughing Endmill Ø12 Z2

A01-800

The endmill with faceted roughing profile on O.D. is a typical roughing tool in woodworking and plastic industry. The roughing profile is ground with a standard 1V1 wheel with 45° or 12V9 wheel.



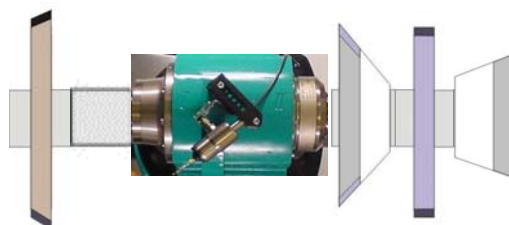
1. Cycletime for Production

Workpiece: Ø 12 mm, Z 2, Length 40 mm, Helix 20° Material CARBIDE									
Operations									
Feed [mm/Min]	2000	80	70	100	100	150	200	60	120
Power [kW]		8	2	2	1	1	2	1	1
Cutting feed [m/s]		18	18	22	22	22	22	22	22
Used wheels									
Grinding time [s]	15	89	87	21	76	53	43	30	19
Total cycle time	7 Min 13								

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 D64
2	12V9 Ø125 D64
3	1V1 Ø125 D64
4	11V9 Ø100 D64



3

2 1 4

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR

Control: Fanuc 31i

Accessories:

Responsible engineer: OP. 15.11.10

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

www.schneeberger.ch

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